

Date: Monday, 18/08/2008 10:22:44 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SWING ARM
Job Number :	41278		
Estimate Number :	11303		
P.O. Number :		Part Number :	D34479
This Issue :	18/08/2008	Drawing Number :	D3447
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	A
Previous Run :	39968	Material :	
Written By :		Due Date :	15/09/2008
Checked & Approved By :	JLP 08.8.18	Qty:	8
Comment :	Est A 05.08.26 New issue KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M7075T6B1500X1500	7075 T6 BAR 1.500 x 1.500
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Comment: Qty.: 0.7350 f(s)/Unit Total: 5.8800 f(s)
 7075 T6 BAR
 Material: 7075-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M7075T6B1.500x01.500)
 Identify for D3447-9
 Batch: M18147

(8)

N.A 08/08/21

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 1.500" x 1.500" x 8.400" long

(8)

N.A 08/08/21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA544 and Dwg B67-43001
 Identify as D3447-9Dwg Rev A Folio Rev A
 Deburr

(8)

N.A 08/08/26

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(8)

N.A 08/08/26

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

N.A 08/08/27 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/25		One part have a mark because of the rougher was too low in the prog.	<i>[Signature]</i> 08.08.25	Buff mark out. is given Part is given	<i>[Signature]</i> 08/08/25	<i>[Signature]</i> 08/08/25	<i>[Signature]</i> 08.08.25	<i>[Signature]</i> 08/08/25
		R.C rougher thinner even		No Replac. Qty @				

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 10:22:44 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SWING ARM

Job Number: 41278

Part Number: D34479

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l 08/08/28

7.0

POWDER COATING

POWDER COATING



M 102316



(8x)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask inside holes as per Dwg D3447 prior to painting

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*2:15
320 OF
2:45*

m-l 08/08/28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/08/28 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *134*

08/08/28

(x8)

54

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8) 08/08/29

Job Completion



W 08-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41278
Description: Swing Arm		Part Number: D3447-9
Inspection Dwg: D3447 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.02	+/-0.030	8.016	✓			
7.075	+/-0.005	7.074	✓			
R0.38	+/-0.030	R0.380	✓			
Ø0.375	+0.006/-0.001	Ø0.380	✓			
0.75	+/-0.030	0.750	✓			
0.375	+/-0.005	0.376	✓			
0.470	+/-0.005	0.4725	✓			
1.100	+/-0.010	1.103	✓			
0.71	+/-0.030	0.708	✓			
0.178	+/-0.010	0.179	✓			
1.825	+/-0.010	1.821	✓			
2.375	+/-0.010	2.376	✓			
R0.25	+/-0.030	R0.250	✓			
R0.13	+/-0.030	R0.130	✓			
3.700	+/-0.010	3.700	✓			
0.25	+/-0.030	0.250	✓			

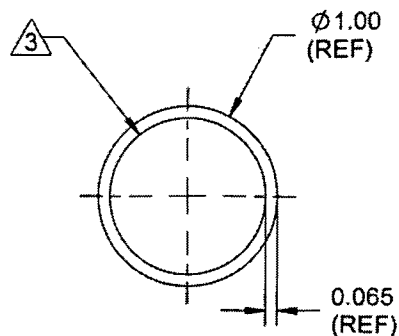
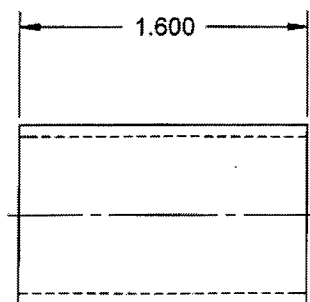
Measured by: JF / H.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/08/25 08/08/26	Date: 08/08/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD [Signature]	[Signature]



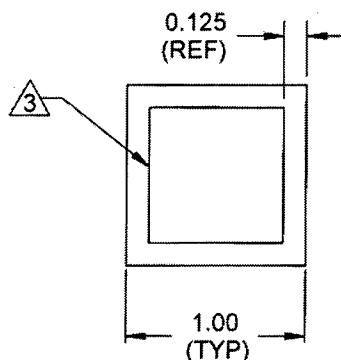
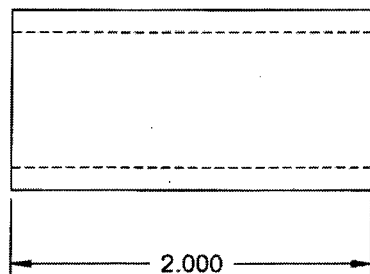
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 1 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED
05/08/18



D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)



D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

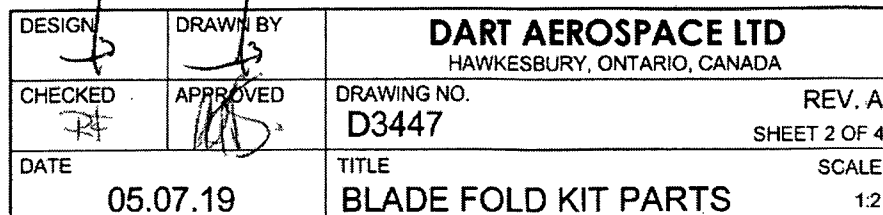
NOTES:

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSN 005 4.3.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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41278

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RELEASED
05/08/18



- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

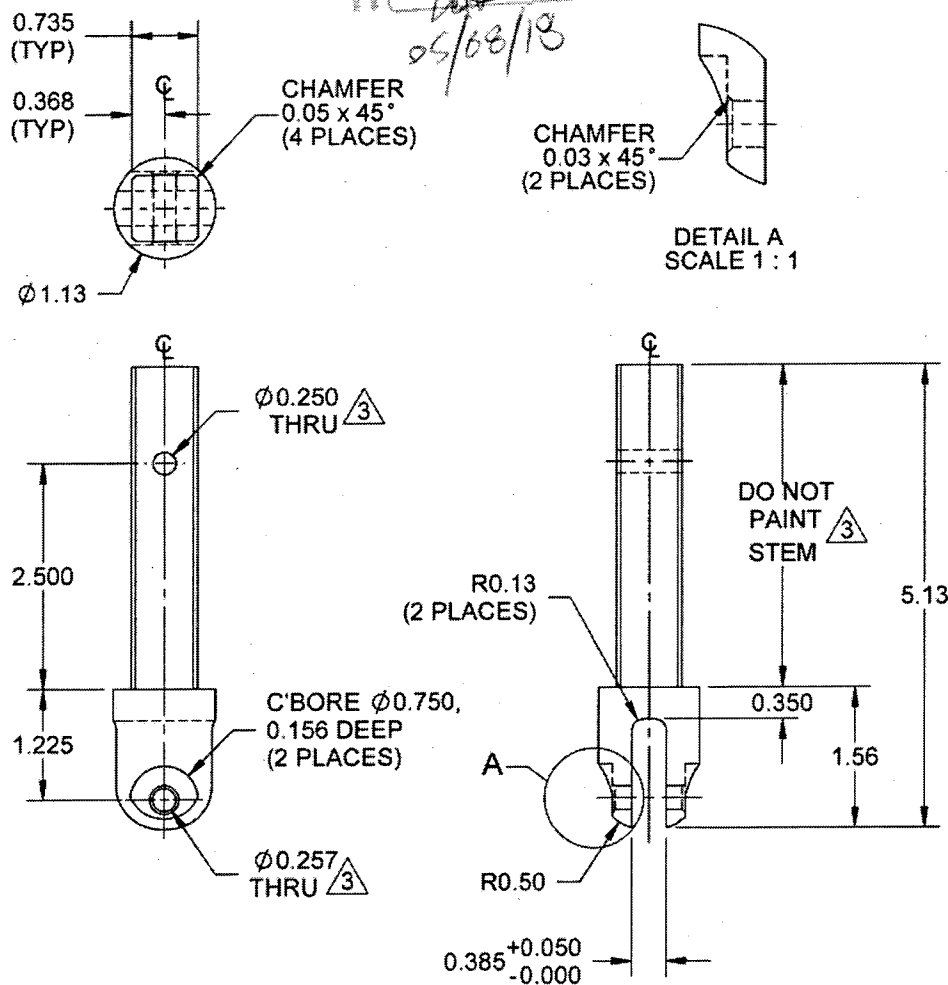
1005 4.3
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 3 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



D3447-7 CLEVIS

SUPERCEDES PREMIER P/N B67-43001-145/-345

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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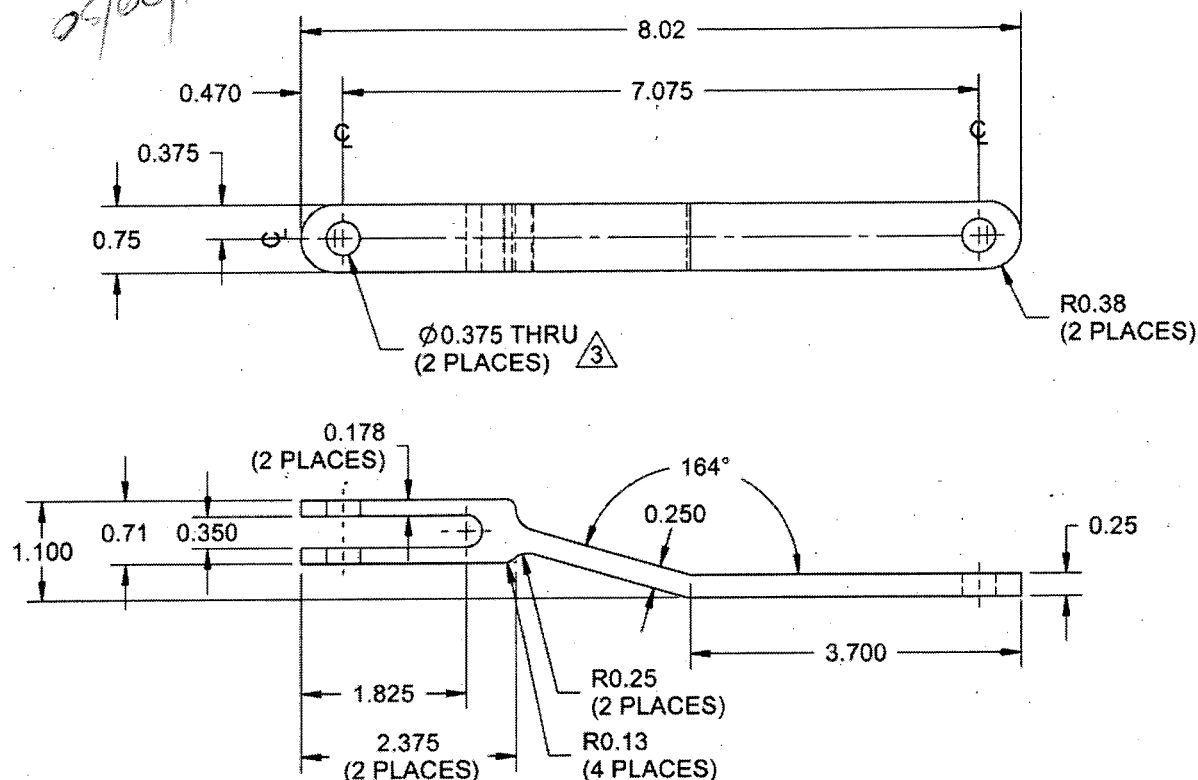
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

RELEASED
[Signature]
05/08/18



D3447-9 SWING ARM
SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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